

Date: Friday, 01/08/2008 1:03:55 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 40929		
Estimate Number	: 11041		
P.O. Number	:	Part Number	: D2809
This Issue	: 01/08/2008 S.O. No. :	Drawing Number	: D2809 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 39727	Material	:
Written By	: <u>08.08.01</u>	Due Date	: 08/08/2008 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est C 02.03.07 Now turned in house NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6R0500	6061-T6 Round Bar .500"
-----	--------------	-------------------------



21

Comment: Qty.: 0.1045 f(s)/Unit Total : 2.0895 f(s)
6061-T6 Round Bar .500"
Material: 6061-T6 (QQ-A-250-11) rod .500"Ø

Batch: 1105671

mmf= 08/08/02

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



21

Comment: HARDINGE CNC LATHE SMALL
Machine as per Folio FA204

mmf= 08/08/02

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



21

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf= 08/08/02

4.0	QC8	SECOND CHECK
-----	-----	--------------



21

Comment: SECOND CHECK

mmf= 08/08/02

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



21

Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & deburr all sharp edges as per dwg

R12/SAN

08/08/25

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 40929

Part Number: D2809

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ML 08/08/25 (21X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder coat WHITE per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*7^h 30^m
320 °F
8^h 00^m*

ML 08/08/26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-26

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *48*

8/8/26

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



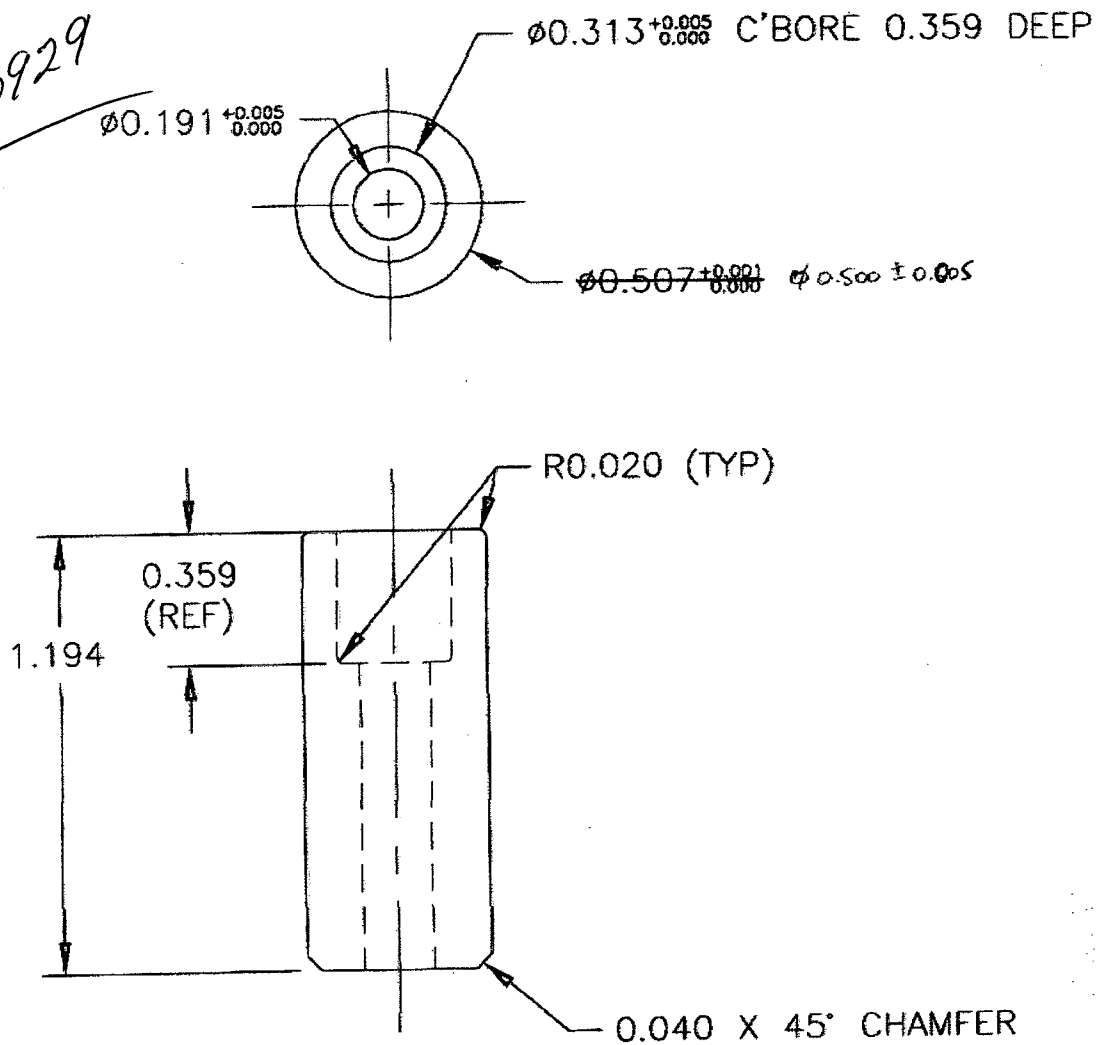
W 08.08.26



DESIGN <i>#</i>	DRAWN BY <i>#</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>#</i>	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	<i># CP</i> 01.04.26	ADD POWDER COAT ; $\phi 0.500$ WTS $\phi 0.507$	

RELEASED
00.11.13 *CP*

w/o 40929



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

PER DART QSI 005 4.3